

Work Order ID 82651

82651

Page 1

April-04-12 10:23:59 AM

Item ID: D3282-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Float Web (206L/407)
 Start Date: 04/04/2012 Start Qty: 10.00 ***10*** Cust Item ID:
 Required Date: 03/05/2012 Req'd Qty: 10.00 ***10*** Customer:
 Reference:

Approvals: Process Plan: MLJ Date: 12/04/04 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3282	D								
100	Skidtubes	0.00							
100									
Skidtubes	Memo	0.00							
Skidtubes	1-Cut to length as per Dwg D3282. 2- inspect for surface damage as per QSI0018 3- Deburr								
110	HAAS CNC VERTICAL MACHINING #1	0.00							
110									
HAAS 1	Memo	0.00							
HAAS CNC vertical machine #1	1-Machine as per Folio FA579 & Dwg D3282 2-Deburr								
120	QC2- Inspect parts off machine FAI/FAIB	0.00							
120									
QC	Memo	0.00							
Quality Control									

> CF 12-4-4

SL/BA 12/05/01

SL/BA 12/05/01

10 0

10 0

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00		2-5-2		1	4		
140 *140* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00							7/6 12-5-2
150 *150* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00							12-5-15

Dart Aerospace Ltd

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N900040100

Setup	Start	*NS1*
	Stop	*NS2*

Start Date: 04/04/2012	Start Qty: 10.00	*10*
Required Date: 03/05/2012	Req'd Qty: 10.00	*10*

Cust Item ID:
Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Run	Start	*NR1*
	Stop	*NR2*

[illegible]

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	QC21- Final Inspection - Work Order Release	0.00							
190									
QC	Memo	0.00							
Quality Control									

12/5/02

12-05-17

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

April-04-12 10:24:03 AM

Page 1

Work Order ID: 82651

82651

Parent Item: D3282-041

D3282-041

Parent Item Name: Float Web (206L/407)

Start Date: 04/04/2012

Required Date: 03/05/2012

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP Rev:B05.09.23Procedure changeKJ/JLM IPP REV:C 11.09.20
remove LPS as per dwg revD DD verf:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2792-130 *D2792-130* EXTRUSION		Manufactured	No			100	Each	31.0000	1	10			
									**	(10)		CF 12-4-4	
					<u>Location</u>	<u>Loc Qty</u>		<u>Loc Code</u>					
					MAT006	31							
					72839	31							
D3283-1 *D3283-1* Doubler		Manufactured	No			160	Each	20.0000	2	20			
									**	(20)		CF 12-5-15	
					<u>Location</u>	<u>Loc Qty</u>		<u>Loc Code</u>					
					ST036	20							
					73611	4							
					74314	16							
MS20470AD4-7 *MS20470AD4-7* Rivet, Universal Head		Purchased	No			160	Each	1,151.000	57	570			
									**			CF 12-5-15	
					<u>Location</u>	<u>Loc Qty</u>		<u>Loc Code</u>					
					ST319	877							
					120769	877							
					ST320	274							
					116081	117							
					117887	9							
					118614	148							
					B121415								
										(114)			

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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	82657
Description: Float Web		Part Number:	D3282-041
Inspection Dwg: D3282	Rev: D	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
126.6	+/-0.100	126.6	/		m-tape	
1.500	+/-0.010	1.500	/		vern	SL-10
3.000	+/-0.010	3.000	/		Vern	GA-01
6.000	+/-0.010	6.000	✓		"	"
1.250	+/-0.010	1.250	✓		"	"
30.000	+/-0.010	30.000	✓		Tape	GA-12
1.500	+/-0.010	1.500	✓		Vern	GA-01
72.01	+/-0.030	72.01	✓		Tape	GA-12
61.75	+/-0.030	61.75	✓		"	"
57.50	+/-0.030	57.50	✓		"	"
49.19	+/-0.030	49.19	✓		"	"
43.94	+/-0.030	43.94	✓		"	"
39.69	+/-0.030	39.69	✓		"	"
26.68	+/-0.030	26.68	✓		"	"
0.55	+/-0.030	0.549	/		vern	SL-10
1.970	+/-0.010	1.971	/		-	"
2.38	+/-0.030	2.377	/		-	"
0.05	+/-0.030	0.049	/		-	"

Measured by: JLB	Audited by: [Signature]	Preliminary Approval:
Date: 12-04-20	Date: 12-5-2	Date:

Rev	Date	Change	Revised by	Approved
A	07.04.02	New Issue	KJ/JLM	
B	12.02.01	Dwg Rev updated	KJ	[Signature]

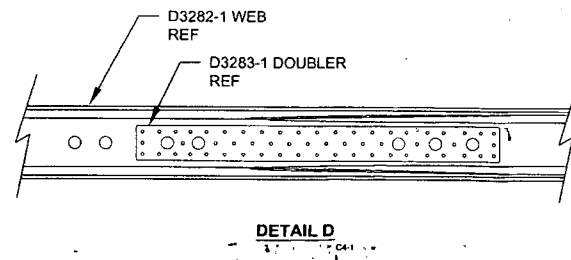
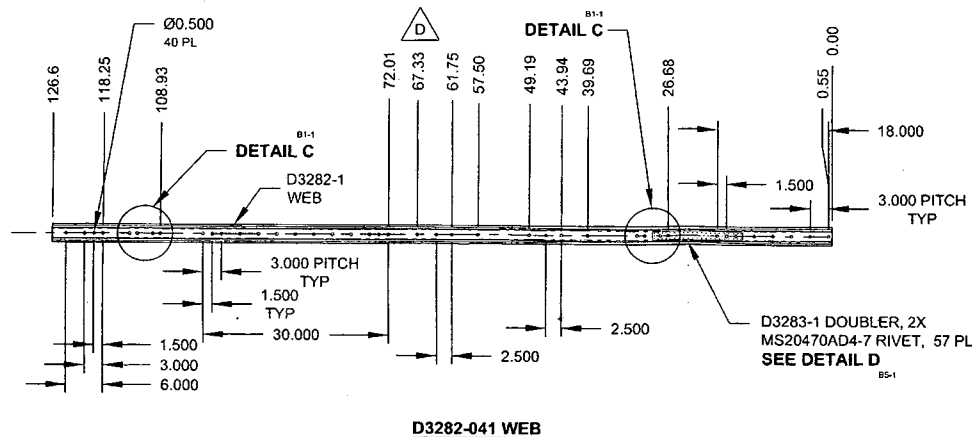
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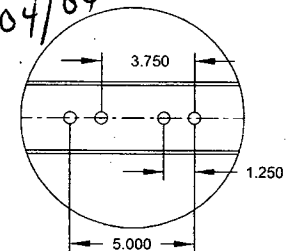
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NOTE: Date & initial all entries



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 82651 MLJ

12/04/04



DETAIL C
D6-1
D6-1

NOTE: RIVET HOLES/DOUBLER
NOT SHOWN FOR CLARITY

RELEASED
2011-09-12

NOTES:

- 1) MAKE D3282-1 WEB FROM D2792-130 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 6) IDENTIFICATION: IDENTIFY WITH P/N "D3282-041" PER QSI 044 6.1 (FINE POINT PERMANENT INK MARKER)
- 7) WEIGHT: 20.0 lbs
- 8) SEE PAGE 2 FOR MACHINING DETAILS

D	ADD ADDITIONAL HOLE (ZN D6-1); REMOVE LPS-3 (ZN C3-1)	SC	11.05.05
C	REMOVE D3390-1, NOW MACHINED	CP	05.08.09
B	MOVE HOLES, ADD D3390-1 DOUBLERS	CP	05.03.16
A	NEW ISSUE	CP	04.05.05
REV.	DESCRIPTION	BY	DATE
DESIGN	CP	DART AEROSPACE USA, INC PORT HADLOCK, WA	
DRAWN	SC		
CHECKED	9	DRAWING NO.	REV. D
MFG. APPR.	EE	D3282	SHEET 1 OF 2
APPROVED	40	TITLE	SCALE
DE APPR.	44	WEB	NTS
DATE	11.05.05	COPYRIGHT © 2004 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY FORM OR BY ANY MEANS WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

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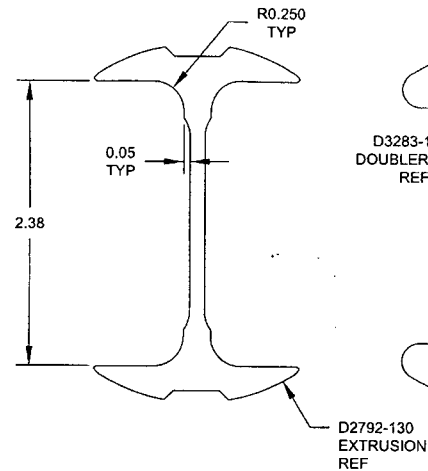
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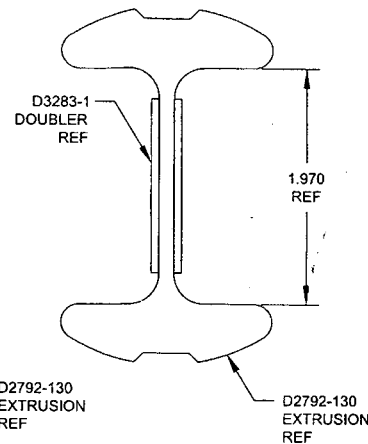
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82657

SECTION A-A

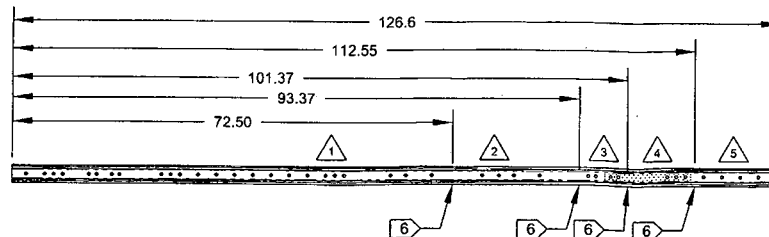


SECTION B-B



D3282-1 MACHINING NOTES

- 1 UNIFORM SECTION A-A
- 2 UNIFORM TAPER FROM SECTION A-A TO SECTION B-B
- 3 UNIFORM SECTION B-B
- 4 UNIFORM TAPER FROM SECTION B-B TO SECTION A-A
- 5 DRILL #30 (Ø0.128 REF) HOLES (57 PLACES) TO LINE UP WITH D3283-1, SEE DETAIL D FOR REFERENCE
- 6 UNIFORM SECTION A-A
- 6 R1.00 BETWEEN SECTIONS



RELEASED
R 2011-09-12

DESIGN	CP	DART AEROSPACE USA, INC	
DRAWN	SC	PORT HADLOCK, WA	
CHECKED	SC	DRAWING NO.	REV. D
MFG. APPR.	SC	D3282	SHEET 2 OF 2
APPROVED	SC	TITLE	SCALE
DE APPR.	SC	WEB	NTS
DATE	11.05.05	<small>COPYRIGHT © 2004 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

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